



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

RBE703A95-0508-00-1
Job Sheet 173935



Part No: RBE703A95-0508-00-1

Job Qty: 6 ea

Part Name: Quill



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 4/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

DW 6 RBE703A95-0508-00 Rev 5C

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		3/31/18	0.00	0.00	Start Up Machining-4		
110	CNC Lathe	6 pcs		4/2/18	0.00	6.00	MORI SL-154		
120	QC	6 pcs		4/2/18	0.00	0.00	QC2		
130	QC	6 pcs		4/2/18	0.00	0.00	QC8		
140	QC	6 pcs		4/2/18	0.00	0.00	QC5		
150	Outsource	6 pcs		4/14/18			ATC001-VC ALTECH 10		
160	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging2		
170	QC	6 pcs		4/14/18	0.00	0.00	QC6		
180	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging3		
190	QC21-SA	6 Ea		4/14/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB651 FOLIO REV: _____ DWG REV: 5C 2-Deburr

Descriptions: 140 - Engrave T/N (RBW6405G08732-3G) And S/N number Using Marktronic engraver as per DWG.

150 - -Issue P/O to ATC: PO 040147 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0508-00 Rev 5C

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.125	6061 Round Bar 1.125	2.1000 ft (.35 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.125	2	15	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 3/8/18 8:13 AM Dart.lajeunesse.marie

Container No: S078327



Part: RBE703A95-0508-00-1

Job No: 173935

Serial No/Batch: S078327

Revision: 5C

Inspector:

Exp Date: 06/06/2018

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

DART AEROSPACE LTD	Work Order: 173935
Description: Quill	Part Number:
Inspection Dwg: RBE703A95-0508-00-1 Rev: 5C	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.140	$\pm .005$	.140			Vern LPOB	
.057	$\pm .005$	.053				
.274	$\pm .005$	.274				
.370	$\pm .005$	.371				
.02 x 30°	$\pm .01$ x .5°	.02 x 30°				
Ø.384	$\pm .005$	.384				
Ø.732	$+.000 / -.002$	.731			Mic LPOI	
4.01	$\pm .01$	4.008			Vern LPOB	
1.35	$\pm .01$	1.348				
.080	$\pm .005$	.080				
.300	$\pm .005$	.298				
Ø.498	$\pm .001$	.4982			Mic LPOI	
Ø.470	$+.000 / -.005$	.4675			Vern LPOB	
Ø.500	$+.000 / -.005$	.498				
Ø.492	$+.000 / -.002$	.491			Mic LPOI	
Ø.426	$\pm .005$	.426			Vern LPOB	
.092	$\pm .005$	.094				
1.471	$\pm .005$	1.471				
1.996	$\pm .005$	1.996				
.335	$\pm .005$	.335				
30°	$\pm .5°$	30°			Opt Comp	
Ø.250	$\pm .005$	.252			Vern LPOB	
.11	$\pm .01$	.109			H.b.	
R.38	$\pm .01$	.375			Rad gage	
Ø1.06	$\pm .01$	1.062			Vern LPOB	
.235	$\pm .005$	.233			H.gage	
.043	$\pm .005$	.045			"	
Ø.130 x .112	$\pm .005$	.125 x .100			Vern LPOB	

Measured by:	Checked by:	QC Inspector:
Date: 18-06-06	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

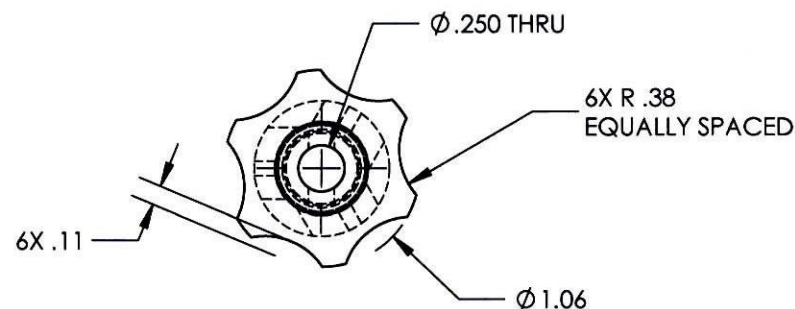
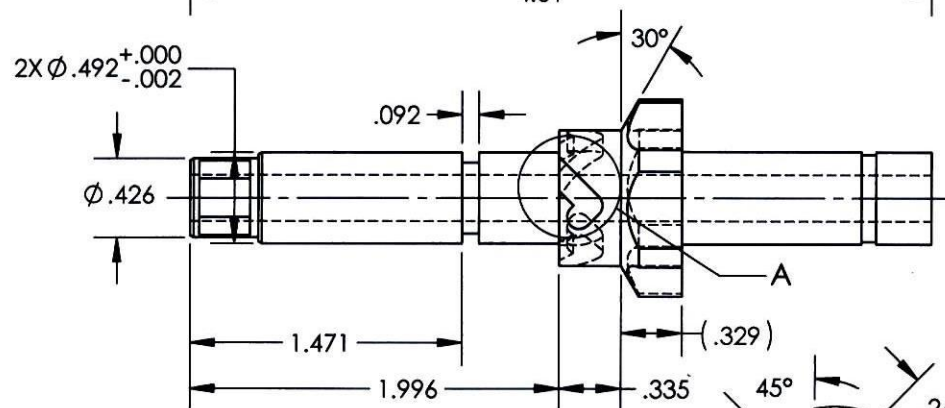
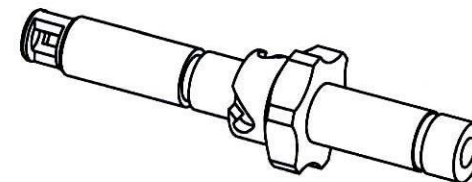
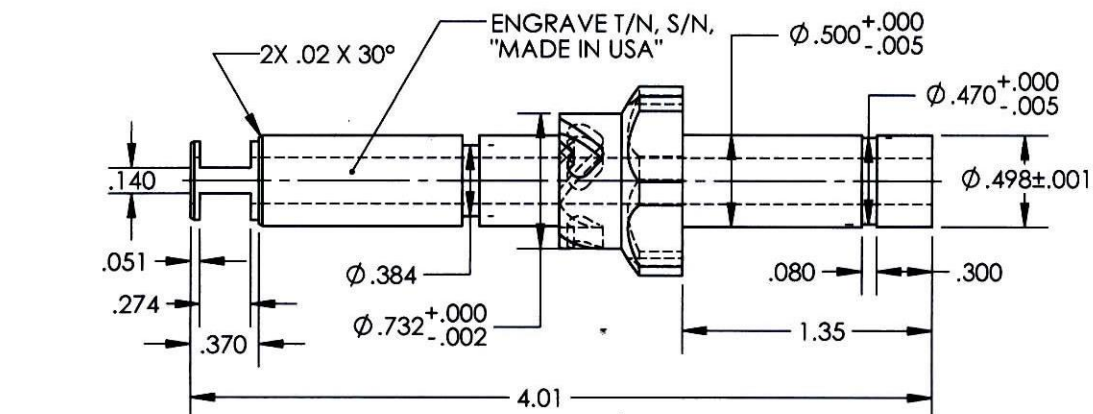
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

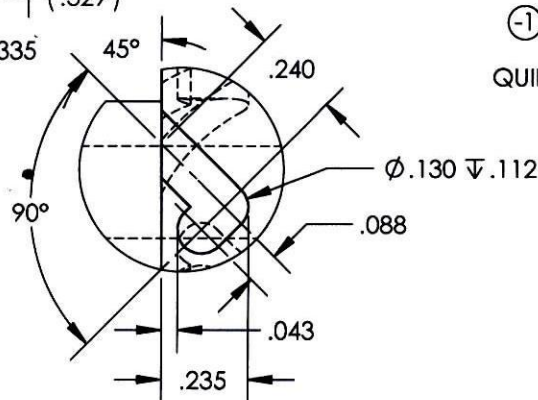
This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D O-RING FROM $\phi 13\text{mm}$ OD x 1.75mm cross section. ADDED NOTES, CH'D SLOTS FROM 90° @ $\phi .131$, AND ID FROM $\phi .230$	5/28/2009	WP
2	CH'D ID FROM $\phi .256$ THRU, CH'D SLOTS FROM 60° @ $\phi .125$ ON HELIX PER G.E.	11/4/2009	RJC
2A	DELETED 20.2° REF. DIMENSION PER G.E.	12/16/2010	RJC
3	CH'D STEM LENGHT FROM .800 TO 1.35, DELETED BARB, ADDED GROOVE	7/31/2012	JAG
4	CH'D 8X R.156 & 8X .12 TO 6X R.375 & 6X .106.	4/17/2013	CFS
5	-1 CH'D DIMS WAS 6X .106 IS 6X .11, WAS 6X R .375 IS 6X R .38.	6/19/2013	BIM



(-1)
QUILL

DETAIL A
SCALE 2 : 1
3X EQUALLY SPACED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173936

RED BARN MACHINE	
TITLE MGB DRAIN TUBE	
DWG NO. RBE703A95-0508-00-1	REV 5C
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Med</i>
.XXX ± .005 FRACTIONS ± 1/32	TREAT
.XX ± .01 ANGLES ± 5°	FINISH RED ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AS350, EC130
SCALE 1:1	DATE 11/12/2008
SHEET 2 OF 2	

20180501



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040147**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040147
PO Date: 6/8/18
Due Date: 6/13/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173895	RBE350A93-3307-00-05	Hex Head Cap Screw -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	6/13/18	6 pcs	0 pcs	6 pcs	\$18.57142860/pcs	\$111.43
2	173935	RBE703A95-0508-00-1	Quill -Issue P/O to GROUPE ALTECH: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0508-00 Rev 5C	Firmed	6/13/18	12 pcs ✓ 12x	0 pcs	12 pcs	\$3.52941176/pcs At 18/06/15	\$42.35
3	173880	RBE350A94-5201-20	Cartridge, Dummy, Fuel -Issue P/O to Groupe Altech: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	6/13/18	10 pcs ✓ 10x	0 pcs	10 pcs	\$3.52941176/pcs At 18/06/15	\$35.29

DAS
38
9-89



Certificat de Conformité / Certificate of Compliance

(010169-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010169 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Jun-2018		Aman		40147				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	RBE703A95-0508-00-1 Rev.	RBE703A95-0508-00-1 01-ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	12	12	0	0	0
3	RBE350A94-5201-20 Rev.	RBE350A94-5201-20 01-ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0
5	RBE703A95-0520-01-1 Rev.	RBE703A95-0520-01-1 01-ANO-RED [ANODIZE RED] ANODIZE COLOR RED PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	12	12	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.